

Date: Wednesday, 11/03/2009 12:58:51 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	:: CROSSBOLT SPACER		
Job Number	: 46434						
Estimate Number	: 10993						
P.O. Number	:			Part Number	: D2579		
This Issue	: 11/03/2009 S.O. No. :			Drawing Number	: D2579 REV E		
Prsh Rev.	: NC			Project Number	: N/A		
First Issue	: / / Type : MACHINED PARTS			Drawing Revision	: E		
Previous Run	: 43988			Material	:		
Written By	:			Due Date	: 04/04/2009 Qty: 200 Um: Each		
Checked & Approved By	: <u>JUL 09 - 03-11</u>						
Comment	: Est E 02.06.17 Now turned on Cobra NG est F 07.07.06 rev E dwg EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0500W058	6061-T6 RD Tube .500 x.058W	
		Comment: Qty.: 0.3762 f(s)/Unit Total : 75.2430 f(s) , 757 ft (ends) 6061-T6 Tube .500 x.058W	
		Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall Batch_M110355	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Factory	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(200)

Comment: FINAL INSPECTION/W/O RELEASE

11/03/15

Job Completion



u 81.83.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46434
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

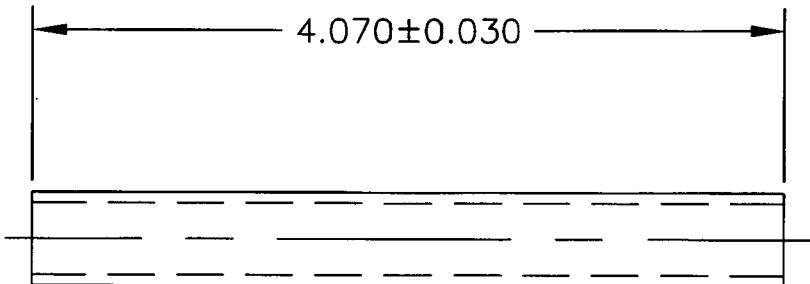
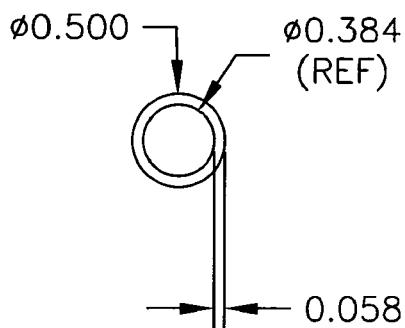
X First Article Prototype

Measured by:	<u>SP</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	09/03/13	Date:	09/03/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	07.09.06	Dwg Rev updated	KJ/JLM	E

DART

DESIGN <i>#</i>	DRAWN BY <i>RS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2579 REV. E SHEET 1 OF 1
DATE 07.04.17		TITLE SCALE CROSS BOLT SPACER 1:1
A	96.09.16	NEW ISSUE
B	96.12.05	0.065 WALL WAS 0.035 WALL
C	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)
E	07.04.17	UPDATE NOTES

RELEASED
07.06.2017**D2579 CROSS BOLT SPACER**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46434

D2579 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T0500W058)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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